

Date: Friday, 27/02/2009 10:36:00 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 46105		
Estimate Number	: 12686		
P.O. Number	:	Part Number	: D35911
This Issue	: 27/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3591 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 43172	Drawing Revision	: B
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 06/03/2009
Checked & Approved By	: <u>JUD 09.02.27</u>	Qty:	30 Um: Each
Comment	: EST A 07.02.01 new issue EC Est Rev:B 08-09-10 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR0500W035

304 RD Tube .500 x .035W



Comment: Qty.: 0.3675 f(s)/Unit Total: 11.0250 f(s)

304 RD Tube .500 x .035W

Batch: M110113ml 09/03/02

(31)

2.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

1-Turn as per dwg D3591

2-Deburr

ml 09/03/02

(31)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 09/03/02

(31)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 09/03/03

(31)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 1109/3/3SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 27/02/2009 10:36:01 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 46105

Part Number: D35911

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/04 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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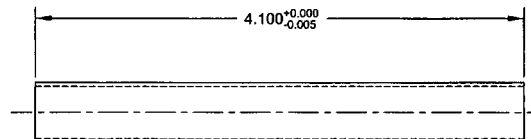
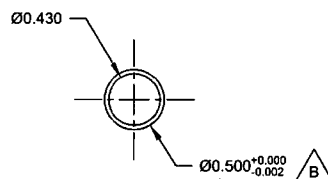
8 7 6 5 4 3 2 1

D

C

B

A







D3591-1 BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44010

RELEASED
08-09-03/11

NOTES:

- 1) MATERIAL: AISI 304/316 SS, Ø0.500, 0.035 WALL SEAMLESS ROUND TUBING
REF. DART SPEC M304TR0.500W.035
OR: AISI 303/304/316 SS, ROUND BAR
REF DART SPEC M303R/M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

B	DRAWING UPDATED TO "B" SIZE FORMAT AND CURRENT STANDARDS. ZN C6 TOLERANCE WAS -0.005. MATERIAL UPDATED TO ALLOW PART TO BE MACHINED TO MAINTAIN TOLERANCE. (SEE NCR 08-074 FOR FURTHER DETAILS.)		AJS	08.08.25
A	NEW ISSUE		PH	07.01.16
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. 1 OF 1	
MFG. APPR.		D3591	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		BUSHING	NT	
DATE	08.08.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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